

Date: Tuesday, 3/11/2008 7:31:24 AM  
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services  
Job Number : 37699  
Estimate Number : 12866  
P.O. Number :  
This Issue : 3/11/2008 S.O. No. :  
Prsht Rev. : NC  
First Issue : 1/1 Type : SMALL /MED FAB  
Previous Run : 37313  
Drawing Name : DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS KIT  
Part Number : D412702043B  
Drawing Number : IIN D412-702 REV E  
Project Number : N/A  
Drawing Revision : E  
Material :  
Due Date : 3/14/2008 Qty: 1 Um: Each  
Written By : AS 08 03 11  
Checked & Approved By :  
Comment : est rev A 07.05.10 new issue EC  
est rev C 07.06.20 changed AN44 4A to AN444A EC  
Est Rev:D 07-07-06 As per Rev E JLM

Additional Product

Job Number: 

Seq. # Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



KS 08.03.13  
①

Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D412-702-043B CHG002

AS 08/03/13

2.0 D412702059 GROMMET KIT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

GROMMET KIT

batch: 32327

AS 08/03/12 (X)

3.0 D412702101B HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HARNESS ASSEMBLY

batch: B32790

AS 08/03/12 (X)

4.0 D412702103B HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32809

AS 08/03/12 (X)

5.0 D412702105B HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HARNESS ASSEMBLY

batch: 32810

AS 08/03/12 (X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Tuesday, 3/11/2008 7:31:24 AM

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS  
KIT

Job Number: 37699

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description:

6.0

D412702107B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HARNESS ASSEMBLY

batch:

B37709

New Batch

AS 08/03/13

(X)

7.0

D412702109B

HARNESS ASSEMBLY



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

HARNESS ASSEMBLY

batch:

~~B37709~~ B37710

New Batch

AS 08/03/13

(X)

8.0

D35421

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

BRACKET

batch:

34221

AS

08/03/12

(X)

9.0

D35711

GUIDE



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

GUIDE

batch:

32829

AS

08/03/12

(X)

10.0

D35713

GUIDE



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

GUIDE

batch:

B3869

AS

08/03/12

(X)

11.0

D3578041

DOUBLER



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

DOUBLER

batch:

36340

AS

08/03/12

(X)

12.0

D3610041

BRACKET



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

BRACKET

batch:

B36085

AS

08/03/12

(X)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: DART 5-MAN 3-POINT FWD FACING SHOULDER HARNESS  
KIT

Job Number: 37699

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description:

13.0

D36181

CAP



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

CAP

batch:

32426

AS

08/03/12

(X)

14.0

AN410A

Bolt



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Bolt

batch:

M101291

AS

08/03/12

(X)

15.0

AN444A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

bolt

batch:

M10486

AS

08/03/12

(X)

16.0

MS24693S274

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch:

M104214

AS

08/03/12

(X)

17.0

MS24694S56

SCREW



Comment: Qty.: 3.0000 Each(s)/Unit Total: 3.0000 Each(s)

SCREW

batch:

M104407

AS

08/03/12

(X)

18.0

MS24694S58

Screw



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Screw

batch:

M11735

AS

08/03/12

(X)

19.0

MS24694S60

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Screw

batch:

M104407

AS

08/03/12

(X)

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: LD Date: 08/03/13  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

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KIT

Job Number: 37699

Part Number: D412702043B

Job Number:



Seq. #:

Machine Or Operation:

Description:

20.0

AN960JD416

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Washer

batch: 106277

AS 08/03/12 (X)

21.0

AN960JD416L

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total: 4.0000 Each(s)

Washer

batch: M106785

AS 08/03/12 (X)

22.0

MS21042L4

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Nut

batch: M105938

AS 08/03/12 (X)

23.0

CR321244

Cherry Rivet



Comment: Qty.: 12.0000 Each(s)/Unit Total: 12.0000 Each(s)

Cherry Rivet

batch: M107214x5 M107008x7

OK from Chantal 4-04 something.  
you should change the part #Because we never have 44  
NOT entered in comp.

AS 08/03/12 (X)

24.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AS 08/03/13 (X)

25.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D412-702-043B CHG001

Location:

PPP Rev: Rev B

AS 08/03/13 (X)

26.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

AS 08/03/13

Job Completion



AS 08/03/13 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
X					D412-702-041B	Dart 13-Man 3-Point Shoulder Harness Kit
	X				D412-702-043B	Dart 5-Man 3-Point Forward Facing Shoulder Harness Kit
		X			D412-702-045B	Dart 4-Man 3-Point Aft Facing Shoulder Harness Kit
			X		D412-702-047B	Dart 4-Man 3-Point Side Facing Shoulder Harness Kit
				X	D412-702-049B	Dart 1-Man 3-Point Forward Shoulder Harness Kit
1	1		1	1	D412-702-059	GROMMET KIT
2	1		1		D412-702-101B	HARNESS ASSEMBLY
1*	1*		1*		D3573-7	ADAPTER
1*	1*		1*		D3579-046	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
2	1		1		D412-702-103B	HARNESS ASSEMBLY
1*	1*		1*		D3573-8	ADAPTER
1*	1*		1*		D3579-045	SHOULDER HARNESS
1*	1*		1*		K6.2	CLIP
4*	4*		4*		MS24693S272	SCREW
4*	4*		4*		AN960JD10LL	WASHER
4*	4*		4*		MS21042L3	NUT
1	1			1	D412-702-105B	HARNESS ASSEMBLY
1*	1*			1*	D3573-1	ADAPTER
1*	1*			1*	D3579-046	SHOULDER HARNESS
1*	1*			1*	K6.2	CLIP
4*	4*			4*	MS24693S273	SCREW
4*	4*			4*	AN960JD10LL	WASHER
4*	4*			4*	MS21042L3	NUT
1	1				D412-702-107B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-046	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT
1	1				D412-702-109B	HARNESS ASSEMBLY
1*	1*				D3573-3	ADAPTER
1*	1*				D3579-045	SHOULDER HARNESS
1*	1*				K6.2	CLIP
4*	4*				MS24693S272	SCREW
4*	4*				AN960JD10LL	WASHER
4*	4*				MS21042L3	NUT

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 07.06.27

QTY -041B	QTY -043B	QTY -045B	QTY -047B	QTY -049B	Part Number	Description
2		2			D412-702-111B	HARNESS ASSEMBLY
1*		1*			D3570-1	BRACKET
1*		1*			D3579-047	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
2		2			D412-702-113B	HARNESS ASSEMBLY
1*		1*			D3570-2	BRACKET
1*		1*			D3579-048	SHOULDER HARNESS
4*		4*			MS24694S50	SCREW
4*		4*			AN960JD10L	WASHER
4*		4*			MS21042L3	NUT
1			1		D412-702-115B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-046	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
1			1		D412-702-117B	HARNESS ASSEMBLY
1*			1*		D3573-5	ADAPTER
1*			1*		D3579-045	SHOULDER HARNESS
1*			1*		K6.2	CLIP
4*			4*		MS24693S272	SCREW
4*			4*		AN960JD10LL	WASHER
4*			4*		MS21042L3	NUT
2	2				D3542-1	BRACKET
7	3		4	1	D3571-1	GUIDE
2	2				D3571-3	GUIDE
2		2			D3572-041	GUIDE ASSEMBLY
12	6		6	2	D3578-041	DOUBLER
2	2				D3610-041	BRACKET
2	2				D3618-1	CAP
4	4				AN4-10A	BOLT
2		2			AN4-16A	BOLT
4		4			AN4-25A	BOLT
2	2				AN4-44A	BOLT
2	2				MS24693S274	SCREW
3	3			1	MS24694S56	SCREW
10	2		8		MS24694S58	SCREW
1	1			1	MS24694S60	SCREW
26	6	20			AN960JD416	WASHER
4	4				AN960JD416L	WASHER
12	6	6			MS21042L4	NUT
24	12		12	4	CR3212-4-4	RIVET

\*DENOTES THAT PART IS INCLUDED WITH ASSEMBLY ABOVE

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Revision: E

Date: 07.06.27